

Split

Work Order ID 133980-1

133980

Tuesday, June 23, 2015 3:26:25 PM

Item ID: D4711-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*

Item Name: Expandable Pin Assembly, Modified

Start Date: 6/23/15 Start Qty: 6.00

Required Date: 6/23/15 Req'd Qty: 6.00

6

6

Cust Item ID:

Customer:

Reference: Run Start *NR1*

Approvals: Process Plan: MJS Date: JUN 24 2015 Tooling: Date: Stop *NR2*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4711	C

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2

FF

AUG 20 2015

120

120

Small Fab

Small Fab

Memo

ASSEMBLE AS PER DWG (see note 8,9,10)

***DO NOT OVERTIGHTEN THE SHAFT INTO THE BARREL PER NOTE

10***

0.00

0.00

2

FF

AUG 20 2015

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2

AUG 20 2015

DAS

38

9-89

Work Order ID 133980

133980

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Item ID: D4711-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Expandable Pin Assembly, Modified

Start Date: 6/23/15 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/23/15 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>ST 123</u>	0.00							AUG 20 2015
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
6
2-20

② JA

MLJ AUG 21 2015

SLS 20150821

Tuesday, June 23, 2015 3:26:24 PM

Work Order ID: 133980

Parent Item: D4711-041

Parent Item Name: Expandable Pin Assembly, Modified

13.3980

D4711-041

Start Date: 6/23/15

Start Qty: 6.00

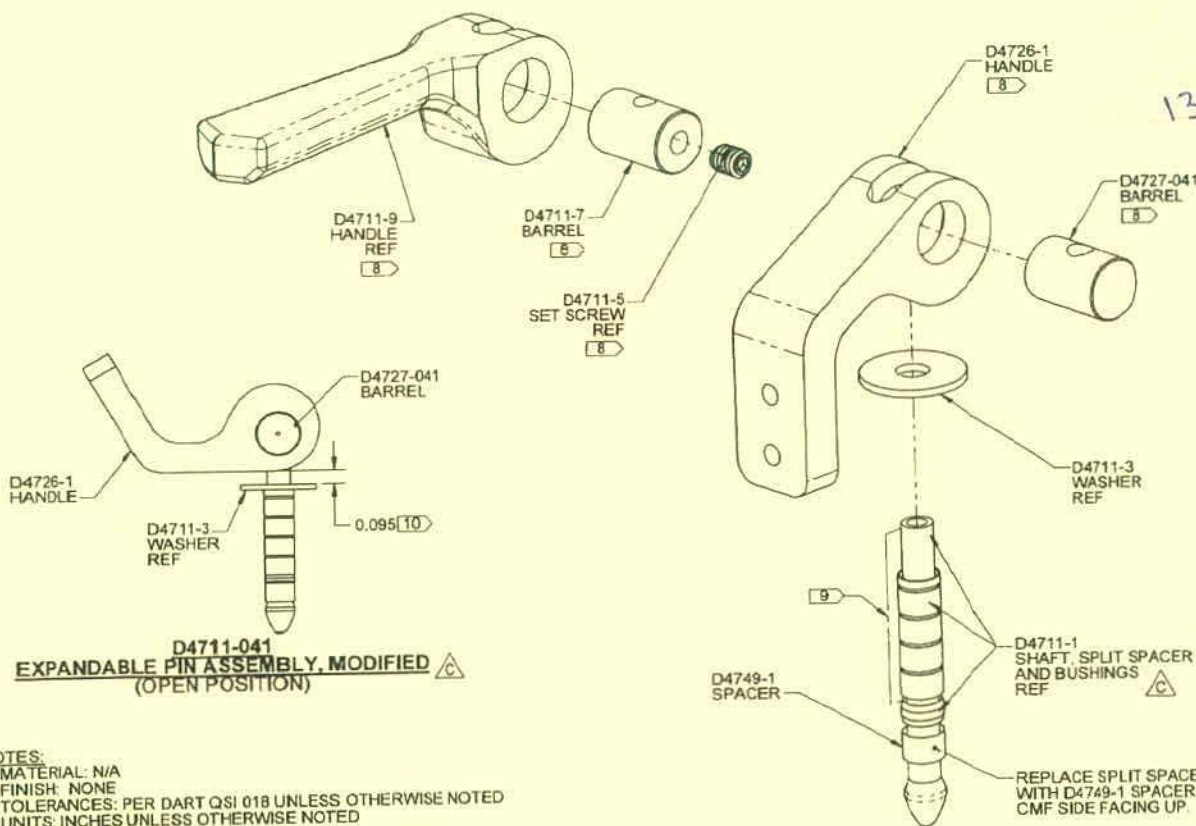
Required Date: 6/23/15

Required Qty: 6.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B
13.03.11 AS PER DWG REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4711-043		Manufactured	No			110	Each	2.0000	1	6		DAS 30 9-89	JUL 07 2015
D4711-043 Expandable Pin Assembly													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST124	135357		2	B 13	3900	2			
				128792			2						
D4726-1		Manufactured	No			110	Each	4.0000	1	6			
D4726-1 Handle													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST125	134539		4			2			
				130061			4			4			
D4727-041		Manufactured	No			110	Each	4.0000	1	6			
D4727-041 Barrel													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST125	134510		4			2			
				127908			4			4			
D4749-1		Manufactured	No			110	Each	11.0000	1	6			
D4749-1 Spacer													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST125	114888		11			2			
							11			6			

ITEM	QTY	P/N	DESCRIPTION
	X	D4711-041	EXPANDABLE PIN ASSY, MODIFIED
1	1	D4711-043	EXPANDABLE PIN ASSY
2	1	D4725-1	HANDLE
3	1	D4727-041	BARREL
4	1	D4749-1	SPACER



**D4711-041
EXPANDABLE PIN ASSEMBLY, MODIFIED
(CLOSED POSITION)**

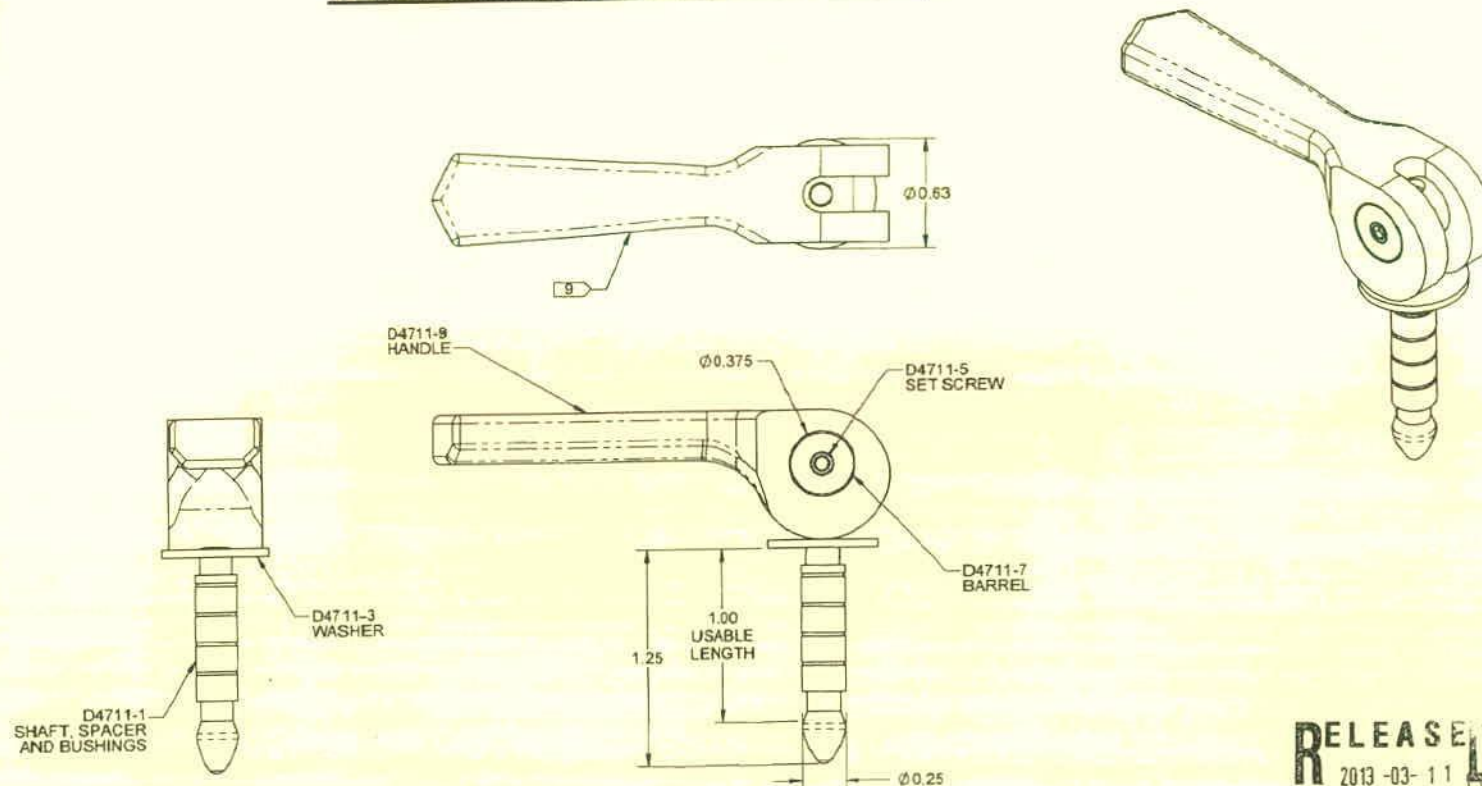
RELEASED
2013-03-11

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4711-041" AND B/N "BXXXXX" PER QSI 044 6.7
- 7) WEIGHT: 0.19 lbs
- 8) REPLACE D4711-9 HANDLE WITH DART D4726-1 HANDLE.
REPLACE D4711-7 BARREL WITH DART D4727-041 BARREL.
REPLACE BOTTOM SPLIT SPACER WITH D4749-1 SPACER.
DISCARD D4711-5 SET SCREW, D4711-7 BARREL, D4711-9 HANDLE, BOTTOM SPLIT SPACER.
- 9) WHEN INSTALLING D4749-1 SPACER, ENSURE THAT ALL RETAINED SPLIT SPACERS AND BUSHINGS REMAIN IN THEIR ORIGINAL SEQUENCE AND ORIENTATION.
- 10) INSTALL THE D4711-1 SHAFT WITH THE ASSEMBLY IN THE OPEN POSITION, UNTIL A GAP OF 0.095" EXISTS BETWEEN THE D4711-3 WASHER AND THE D4726-1 HANDLE. DO NOT OVERTIGHTEN THE SHAFT INTO THE D4727-041 BARREL.

REV.	DESCRIPTION	BY	DATE
C	REVISED NOTE (A4-1) & NOTE 8. ADDED NOTE 10. PICTORIAL UPDATE. ADDED VIEW B8-1	AP	13.02.12
B	ADDED D4749-1 SPACER, MODIFIED NOTES 8 AND 9	AP	12.11.23
A	NEW ISSUE	RP	12.09.19
DESIGN	RP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D4711	SHEET 1 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	ADJUSTABLE DIAMETER PIN	NTS
DATE	13.02.12	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SPECIFICATION CONTROL DRAWING



D4711-043 EXPANDABLE PIN ASSY

RELEASE
2013-03-11

NOTES

- 1) MATERIAL: CORE PIN, SPLIT RINGS & BARREL: STAINLESS STEEL 17-4 PH CONDITION H925 PER AMS 5643
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs
- 8) RECOMMENDED SUPPLIER: MCMASTER CARR P/N 97787A661
- 9) HANDLE, BARREL AND SET SCREW TO BE DISCARDED AT NEXT HIGHER ASSEMBLY

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	at	D4711	SHEET 2 OF 2
APPROVED	at	TITLE	SCALE
DE APPR.	at	ADJUSTABLE DIAMETER PIN NTS	
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